

Date: Wednesday, 03/09/2008 10:34:58 AM  
User: Julie Lecocq

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP WELDMENT
Job Number : 41766	
Estimate Number : 10721	
P.O. Number :	Part Number : D34637
This Issue : 03/09/2008 S.O. No. :	Drawing Number : D3463 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 35882	Material :
Written By :	Due Date : 20/09/2008 Qty: 6 Um: EACH
Checked & Approved By : <u>Julie Lecocq</u>	
Comment : EST REV> A 05.11.18 new issue EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0750W120	304 ss round tube .750 x .120w
<p>Comment: Qty.: 1.0000 f(s)/Unit Total: 6.0000 f(s)  AISI 304 SS seamless tubing 0.750 OD X 0.120 wall  (M304TR0750W120)  Batch: <u>M109162</u> <span style="float: right;">SAD 08/10/03 6</span></p>		
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
<p>Comment: SMALL &amp; MEDIUM FAB RESOURCE 1  1-Cut to 13.875"  2-Deburr  3-Bend end as per dwg D3463 <span style="float: right;">SAD 08/11/03 (2)</span></p>		
3.0	QC5	INSPECT WORK TO CURRENT STEP
<p>Comment: INSPECT WORK TO CURRENT STEP <span style="float: right;">SAD 08/11/03 (46)</span></p>		
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
<p>Comment: CONVENTIONAL MILLING MACHINE  1-Mill as per dwg D3463  2-Drill hole &amp; ream to 0.4385" as per dwg D3463 <span style="float: right;">(6x) X60</span>  3-Deburr <span style="float: right;">Rafidius FF 08/11/26 08/11/09</span></p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: STEP WELDMENT

Job Number: 41766

Part Number: D34637

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DT 08/11/10 (6)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mf 08/11/10 (6)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Carl

JS 08/11/27 (6)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/28 (6)

Job Completion



Smart 6.1 Grind .450"RAD  
FAD

FF 08/11/26 (6)

6.2 QC5

08/11/27 (6)

mf 08-11-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

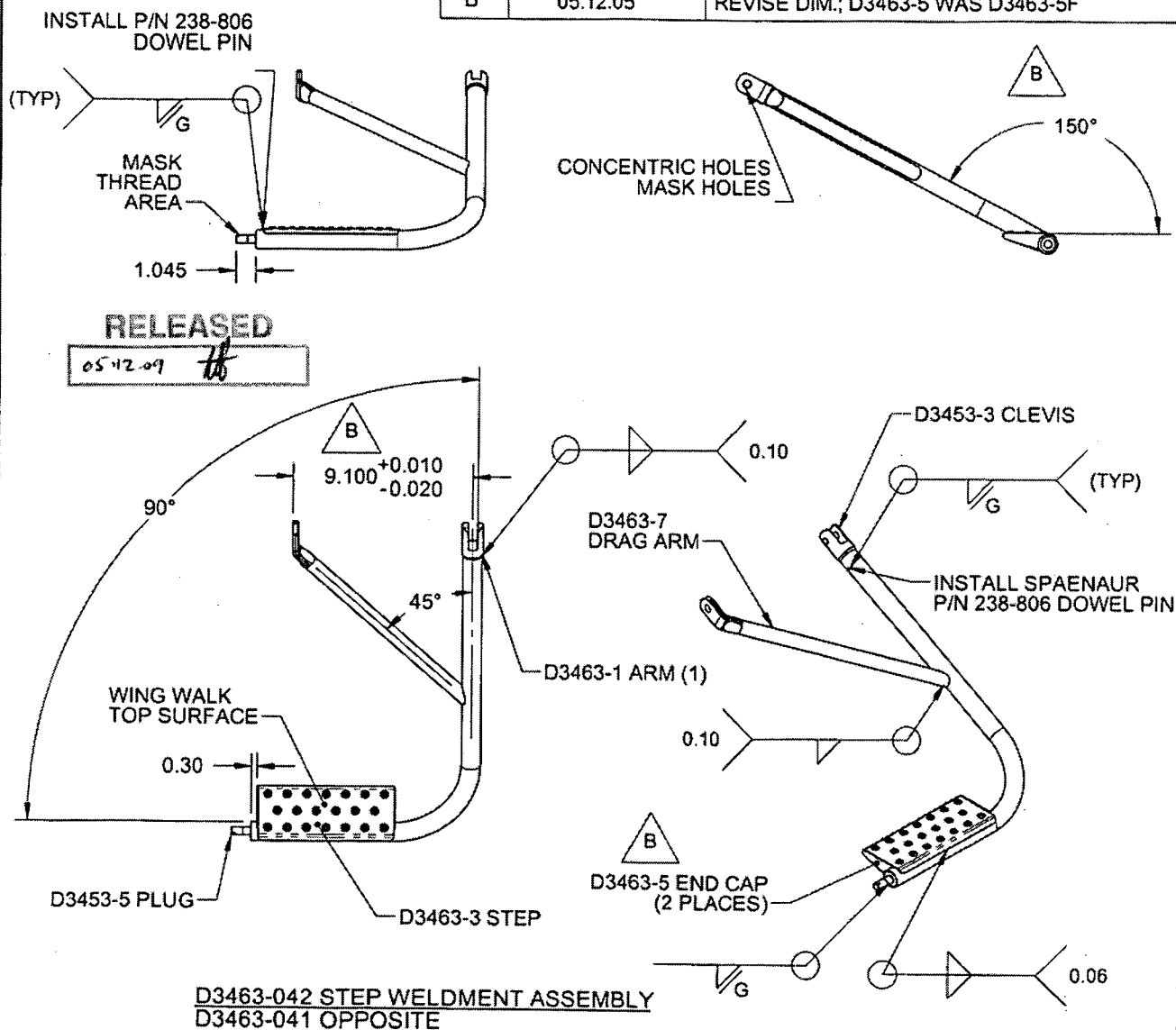
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. <b>D3463</b>	REV. B SHEET 1 OF 4
DATE <b>05.12.05</b>	TITLE <b>STEP WELDMENT</b> SCALE 1:8		
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. *41760*

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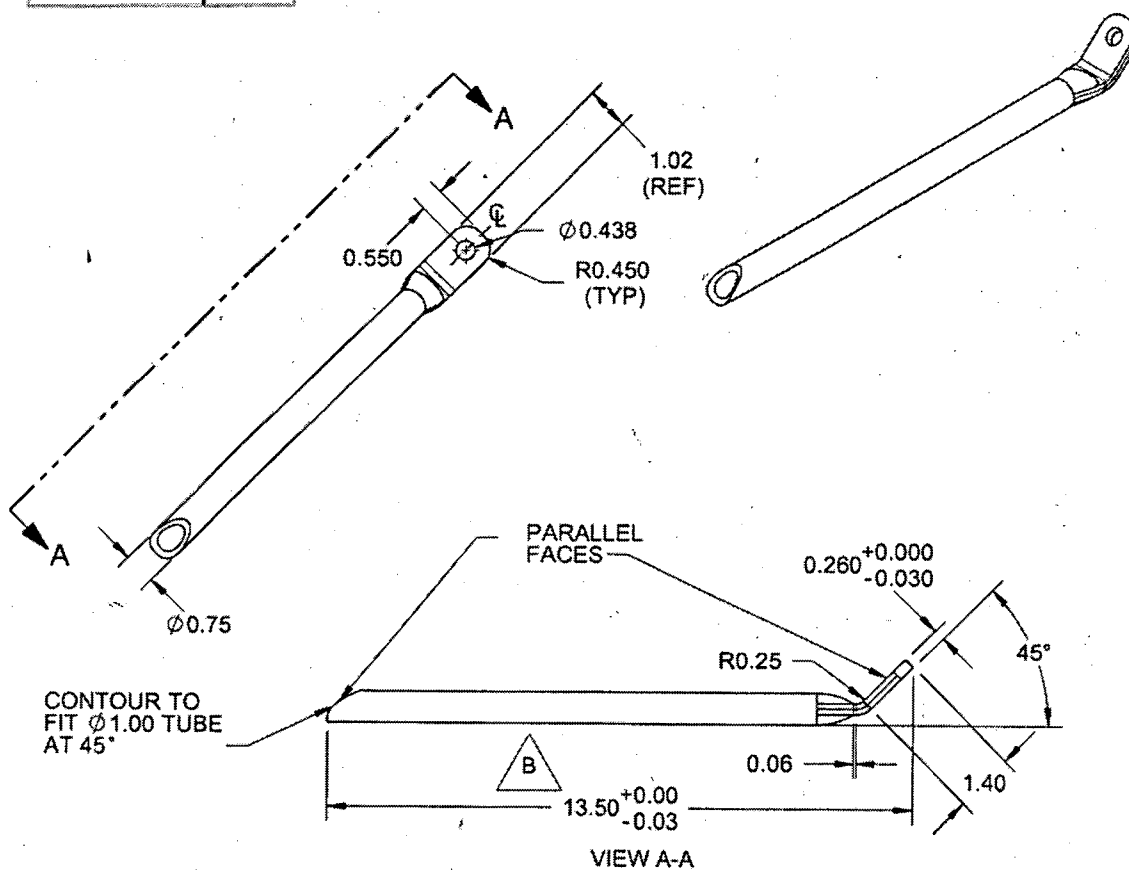




DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 3 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

RELEASED

05.12.05



**D3463-7 DRAG ARM**

**NOTES:**

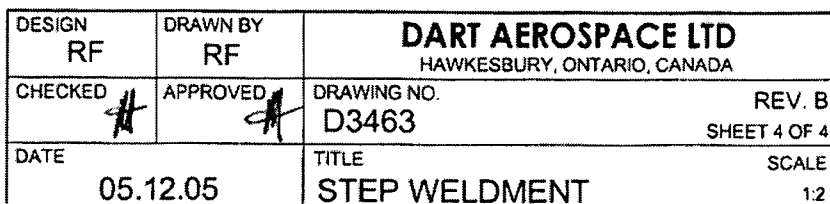
- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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WORK ORDER  
NO. 41766

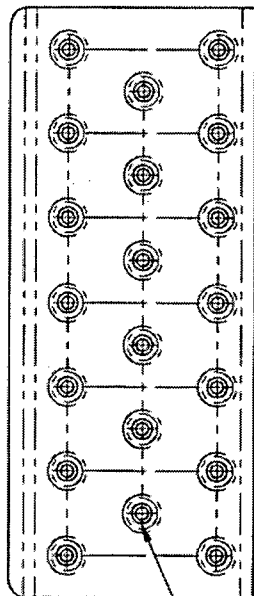
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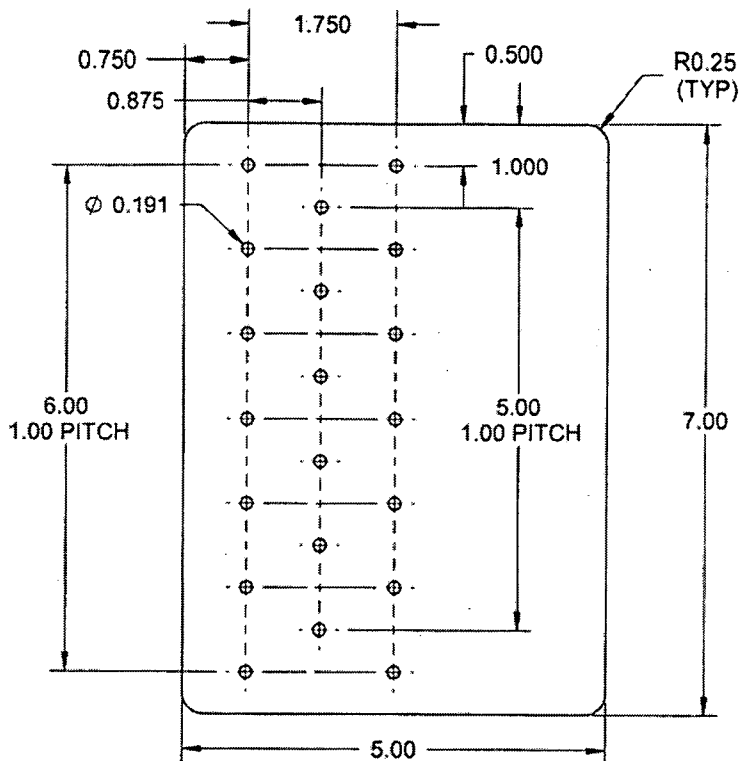




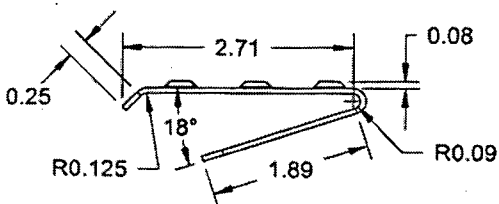
05.12.09 #



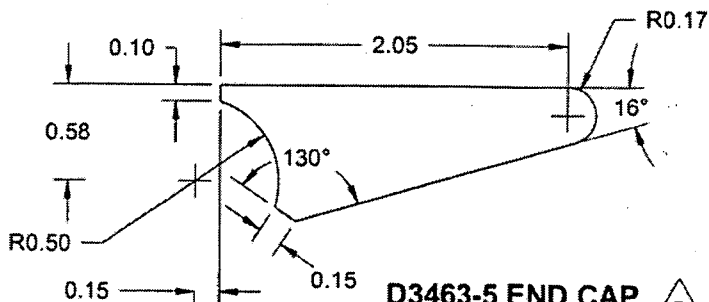
FORM USING  
D3463-3T1



**D3463-3F FLAT PATTERN**



### D3463-3 STEP



**D3463-5 END CAP**  
**SCALE 1:1**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)  
2) FINISH: NONE  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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